Work Orde March-02-12 12		879		*ጸበዖ	R79*						Page 1
Revision ID:	D412-698-01 Cabin Door Ro			Accept	*N900	<b>040</b>	100	)* s	etup Star	IV	IS1*
	02/03/2012	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	<b>D:</b>			·	"IX	
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ite:		R	lun Star	17	IR1*
	QC:		Date:	SPC (Y/N):	Da	ite:			Stop	` *N	R2*
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
IIN D412-698	Rev	E	0								
*1 \\n\* DC  Document Control		DOCUMENT CONTRO Memo Photocopy	DL pluefile and create labels p	0.00 0.00 er PPP D412-698-012 CF	HG003 & (7/c)	elez					· ·
110		Pick Kit		0.00						_ /	
*110* Packaging		Memo		0.00				الالحا	3 I	y) <u> </u>	24/
120		QC4- 100% Inspect kits	for completeness	0.00	<b>\</b>			_			
*120* QC Quality Control		Memo		0.00	à luelez			(Z)			

W/O:			WO	RK ORDER CHANG	GES					*	
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							·				
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQA	\:	Date: _		
	R	esolution:	Disposition	Disposition: Q/					Date:		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (	NCR)	)				
DATE	STEP	Description of NC Section A	Initial	Action Description	etion B	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng		Date				•	
·	*				<u> </u>		ļ				
								;			

\*Work Order ID 80879 Page 2 • 'March-02-12 12:04:27 PM D412-698-012 Item ID: Accept \*N900040100\* **Revision ID:** Cabin Door Roller, RH Item Name: **Start Date:** 02/03/2012 Start Otv: 2.00 **Cust Item ID: Required Date:** 16/03/2012 **Req'd Qty:** 2.00 **Customer:** Reference: Run Process Plan: Date: **Tooling:** Approvals: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool# Plan Reject Reject Set Up/ Accept Insp. **Work Center ID** Description Code Oty Oty Number Stamp **Run Hours** 130 0.00 Packaging \*130\* 0.00 Packaging Memo Packaging Identify and pack for shipping as per PPP D412-698-012 Location: 140 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

\*140\*

Quality Control

V12-04-4

MLJ 12/04/04

		W	ORK ORDER CHAN	GES					,
STEP	PRO	OCEDURE CHA	ANGE	В	, ,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:	PAR #:	Fault Cate	egory:	NCR: Y	es No	DQA	\:	Date:	
		WORK ORD	ER NON-CONFORM	IANCE (N	ICR)				
STEP	Description of NC Section A	Initial Chief Eng	Action Description	Si	gn &			Approval Chief Eng	Approval QC Inspector
		Simor Zing	Onto Eng					,	
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	Resc	:PAR #: Resolution:  Description of NC	PAR #: Fault Cate  Resolution: Disposition  WORK ORD  STEP Description of NC	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC	PAR #: Fault Category: NCR: Y  Resolution: Disposition: QA: N/C  WORK ORDER NON-CONFORMANCE (NOTED TO Section B)  STEP Description of NC Section A   Corrective Action Section B    Initial   Action Description   Si	STEP PROCEDURE CHANGE  By    PROCEDURE CHANGE	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQA  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  :PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC

## **Picklist Print**

\* March-02-12 12:04:32 PM

Work Order ID: 80879

\*80879\*

Parent Item:

D412-698-012

\*D412-698-012\*

Parent Item Name: Cabin Door Roller, RH

**Start Date:** 02/03/2012

**Required Date:** 16/03/2012

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from

Step 1,3KJ/DS

IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

		20 change to re		CIVITO DE									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141	· · · · · · · · · · · · · · · · · · ·	Manufactured	No			110	Each	30.0000	3	6//		· · ·	
*D3121-14	41*								**	4		18	P
· ·				Location	Į.	Loc	<u>Oty</u>	Loc Code		,			
				ST235			30						
					77620		6		_	1-	•		
					78879		12		_	6	•		
20121111					80097		12		_	$-\Lambda$	. (		
D3121-144		Manufactured	No			110	Each	9.0000	$\mathcal{L}^{1}$	2		_	
*D3121-14 Bracket Assembly	44*								**	$\mathcal{V}$		<u>D</u>	P
2				<b>Location</b>		Loc	<u>Qty</u>	Loc Code		•			•
				ST235			4						
					79311		4						
				ST235A			5			<b></b>	_		
					75032		5		٠,	<del>^</del>	$\Lambda$		
D3137-043		Manufactured	No	•		110	Each	6.0000	4.	$^{12}$ 1 1	- 1)		
2 *D3137-04 Bracket Assembly	4.3*								**	12/4/3	P	R	]
•				<b>Location</b>		Loc (	<u>Oty</u>	Loc Code				- •	
				ST235B			6						
					76198		6		C	<i>y</i>			

W/O:			WO	RK ORDER CHANG	ES					*
DATE	STEP	PR	OCEDURE CHAI	NGE	В	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									7, 4	
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: `	Yes N	lo <b>DQ</b>	<b>A</b> :	_ Date: _	
	Re	esolution:	Disposition	:	_ QA: N/	C Clo	sed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:			WORK ORDE	R NON-CONFORM	ANCE (I	NCR)				
DATE	STEP	Description of NC			ion B		Verific		Approval	Approval
	J.L.	Section A ,	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	on C	Chief Eng	QC Inspector
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<sup>®</sup> March-02-12 12:04:32 PM

Work Order ID: 80879

\*80879\*

Parent Item:

D412-698-012

\*D412-698-012\*

Parent Item Name: Cabin Door Roller, RH

**Start Date:** 02/03/2012

**Required Date:** 16/03/2012

Start Qty: 2.00

Required Qty: 2.00

Manufactured

110

Each 2.0000

Manufactured

Manufactured

Loc Oty Location ST -2 75034 ST235B 110 Each

103.0000

Loc Code

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Location Loc Qty ST236 78618 40 45 ST236A 13 61484 73363 75035 76212 78618 5 110 Each

Loc Code

19.0000

Location Loc Oty ST241A 19 70294 19

Loc Code

W/O:			WC	RK ORDER CHANG	iES					
DATE	STEP	PR	OCEDURE CHA	NGE		у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		,					-			
Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo <b>DQ</b>	A:	_ Date: _	
	R	esolution:	Disposition	າ:	_ QA: N	/C Clo	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (I	NCR)				
DATE	STEP	Description of NC			ion B		Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
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IIN-D412-698 Page 23 of 25

#### 6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty	Qty	Qty	Qty	Qty	Qty		
-011	-012	-013	-017	-019	-021	Part Number	Description
Х	17					D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		Х				D412-698-013	DOOR HANDLE KIT
			Х			D412-698-017	REPLACEMENT DOOR TRACK KIT
				Х		D412-698-019	BEARING OVERHAUL KIT
					Х	D412-698-021	REPLACEMENT SHIM KIT
3	/ 3				<u> </u>	_D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
'	1 1						BRACKET ASSEMBLY
1	7 1			~ <del>~~</del>	40-42 N - 1-4	D3127-144	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
<del>'</del>	1					D3183-044	BRACKET ASSEMBLY
9	/ 9		9-			D3199-1	BRACKET
1	71		1	•		D3202-1	COVER
···	<u></u>						
		4	<u></u>			D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
·····				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
	<u> </u>			1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
			-		1	D3238-3	SHIM
<b></b>			<del>                                     </del>		2	D3238-5	SHIM
			<del>                                     </del>		6	D3238-11	SHIM
	-		<del>                                     </del>		2	D3238-11	SHIM
			-	<del> </del>	4	D3238-15	SHIM
<u> </u>			<u> </u>	<u> </u>			OFFICE
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW